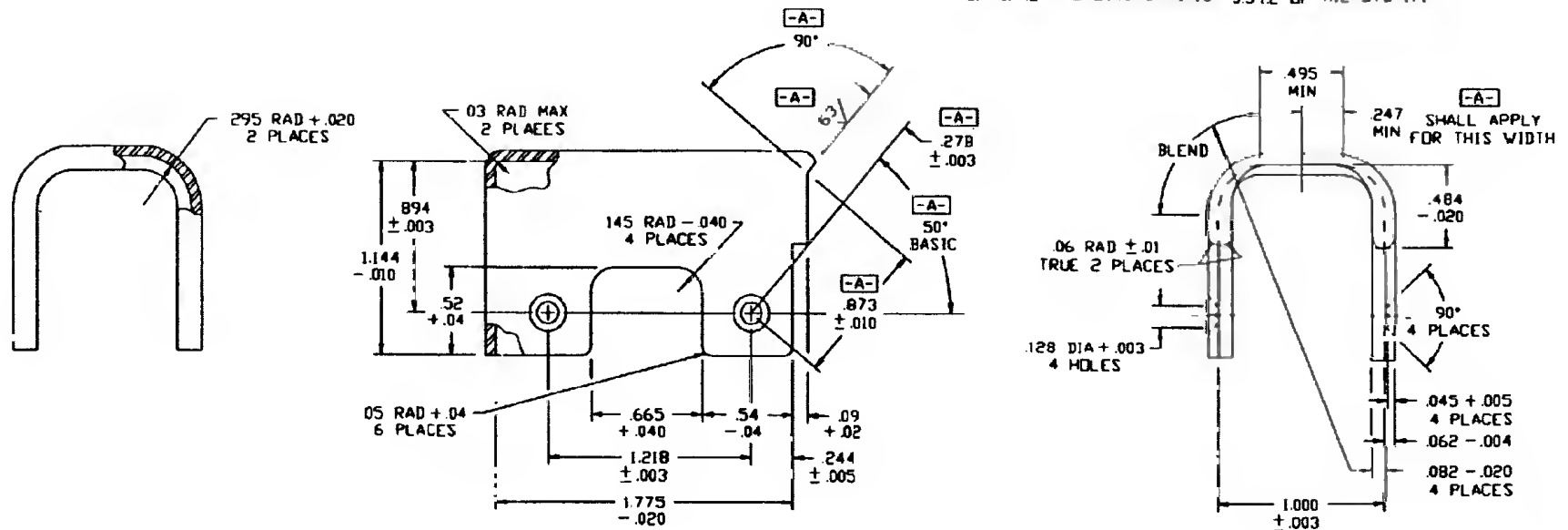


NOTES

1. FINISH $125\sqrt{\text{EXCEPT AS NOTED SHEARED SURFACES } 250\sqrt{\text{}}$
2. ALL EDGES SHALL BE BROKEN .005 + .010 UNLESS OTHERWISE SPECIFIED.
3. MATERIAL- STEEL 00-S-698 CARBON 17 TO 24. MANGANESE .30 TO .60 DRAWING QUALITY KILLED.
4. HEAT TREATMENT- CARBURIZE AT 1600°F FOR .005 TO .010 CASE DEPTH. OIL QUENCH. TEMPER 30 MINUTES AT 350°F. HEAT TREATMENT METHOD IS FOR GUIDANCE. EXCEPT THAT CASE DEPTH AND HARDNESS REQUIREMENT ARE MANDATORY AND TIME AT TEMPERATURE SHALL NOT BE REDUCED BELOW THAT SPECIFIED. THE USE OF STRAIGHT CYANIDE BATH OR CARBONITRIDING PROCESS SHALL NOT BE PERMITTED WITHOUT PRIOR APPROVAL OF THE CONTRACTING OFFICER.
5. FILEHARD TEST IN ACCORDANCE WITH SA-STD-104. (H)
6. FINAL PROTECTIVE FINISH 5312 OF MIL-STD-171



RESTRICTED
MATERIAL

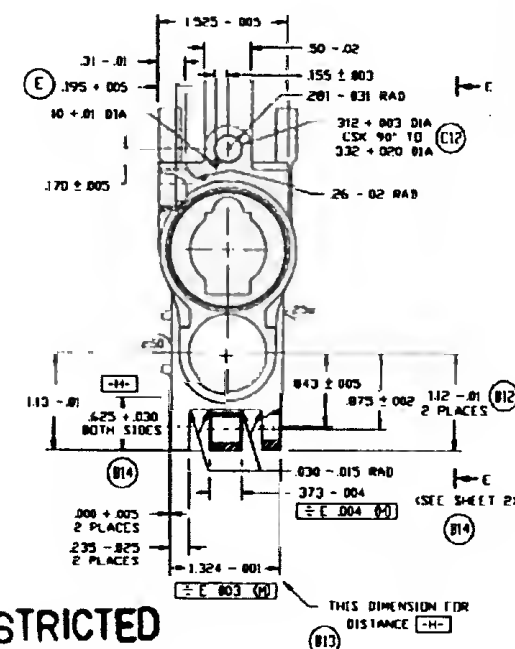
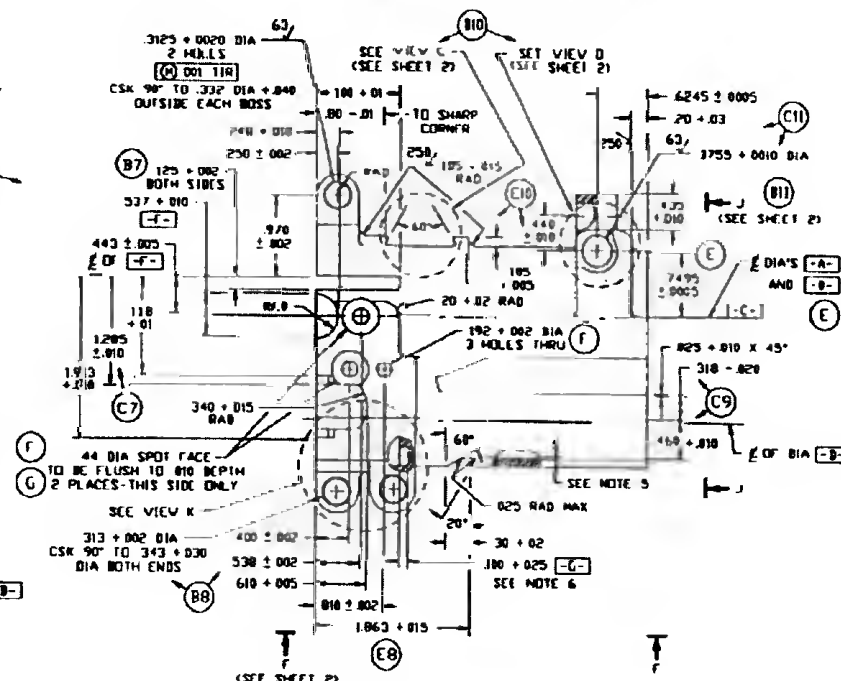
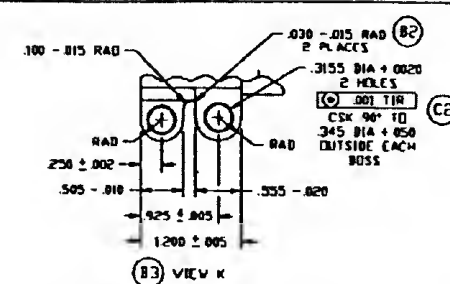
CONFIDENTIAL

NEXT ASSEMBLY	F11686308	MG, 7.62 MM - M60, M60C.
	F11699805	M60D

CODE IDENT NO. 19205
DRAWN FROM ORD PART NO. 7269252
SPRINGFIELD ARMOY ORDNANCE CORPS
DEPT OF THE ARMY
SPRINGFIELD 1, MASS

SYM	DESCRIPTION	SCALE	MATERIAL	CKD	DATE	REV.	NO
G	REDRAWN WITH CHANGE SEE ED NO. SA30116	2 TO 1	SEE NOTE 3				
H	(1) SEE ED HRD 82232		FINISH SEE NOTE 1				
			M60 BRIDGE, RECEIVER				

TOLEANCES
SEC 2 PL $\pm .02$
H N $\pm .01$
SEC 3 PL $\pm .005$
H N $\pm .003$
ANGLES $\pm .5^\circ$



1. FINISH $125\sqrt{\text{EXCEPT AS NOTED.}}$
2. ALL EDGES SHALL BE BROKEN .005 + .010 UNLESS OTHERWISE SPECIFIED.
3. ALL UNSPECIFIED RADII SHALL BE .030 + .030.
4. HEAT TREATMENT- HEAT AT 1535° TO 1565° F. OIL QUENCH. TEMPER ONE HOUR TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
5. BREAK THRU SHALL BE PERMISSIBLE IN THIS AREA PROVIDED RESULTANT BURRS ARE REMOVED.
6. .215 DIA - .015 (2) HOLES MAY BE MACHINED IN CORNERS FOR DEPTH $\frac{1}{8}$ TO PROVIDE REQUIRED RADIUS.
7. FINISH 5.312 OF MIL-STD-171. (G)
8. ALL RIVET HOLES AND THEIR C-SINKS MAY BE OMITTED (D) OR LEFT UNDERSIZE PROVIDED THEY ARE PUT IN AT ASSEMBLY TO THE DIMENSIONAL REQUIREMENTS AT THE COMPONENT LEVEL.
9. MIL-W-13855 APPLIES (C)
10. MATERIAL- STEEL QQ-S-624 4140 , 8640 , 8740.

CONFIDENTIAL

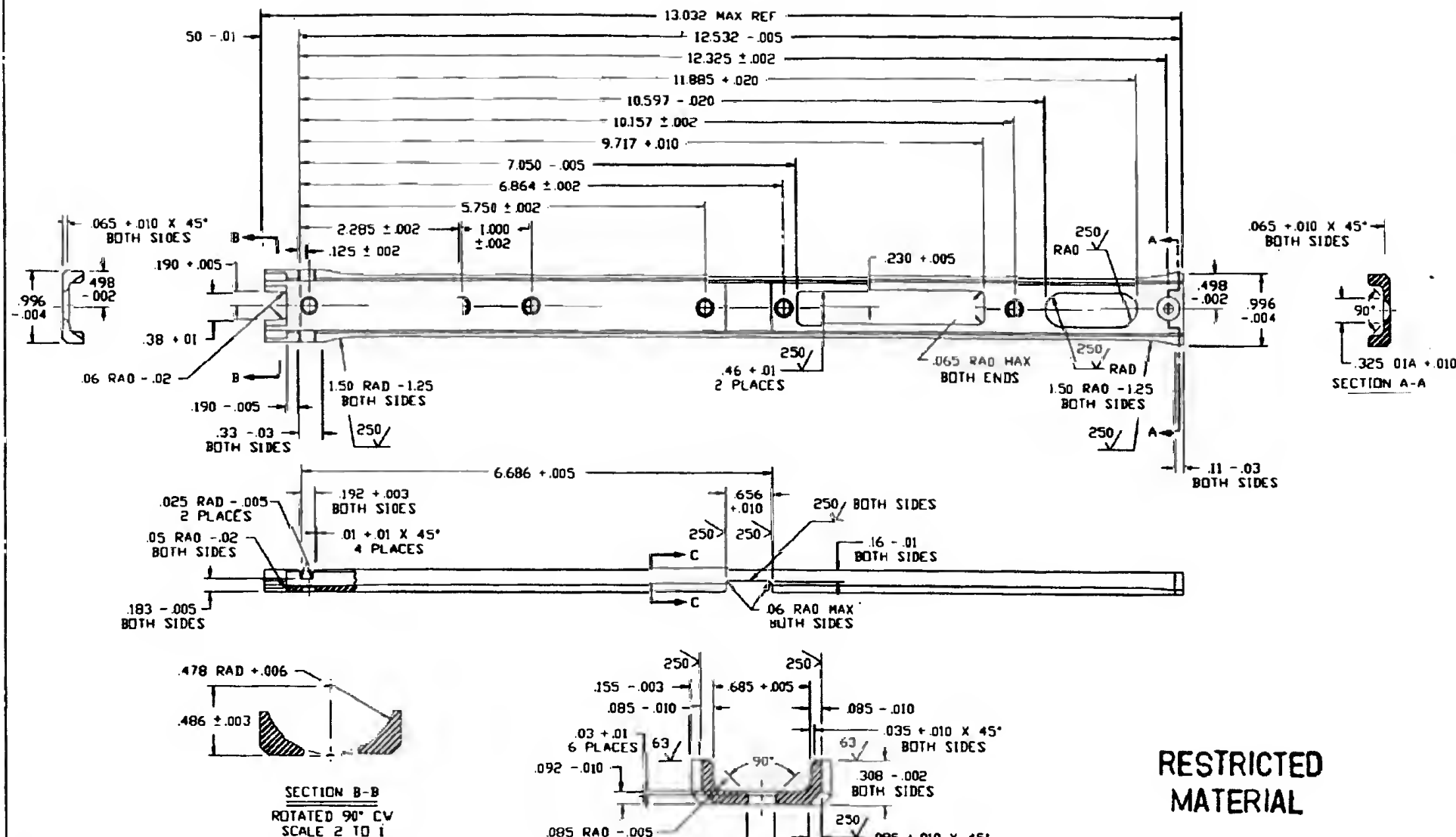
**RESTRICTED
MATERIAL**

SYM	DESCRIPTION
A	SEE ED SA29002
B	(1-14) SEE ED SA30032
C	(1-15) SEE ED 82128
D	(1-2) SEC ED HRD 82232
E	(1-4) SEE ERR HDR 10724
F	(2) SEE ERR HDR 30781
G	(2) SEE HDR 75C 0076-0002

CODE IDENT NO. 19204
DRAWN FROM ORD PART NO. 11686307 SHEET 1 OF 2
ROCK ISLAND ARSENAL
DEPT OF THE ARMY
ROCK ISLAND, ILL.

SCALE:	FULL	MATERIAL:	SEE NOTE 10	DIB:		TOLERANCES:
DATE:		FINISH:	SEE NOTE 1	DATE:		DEC 2 P. : 80 IN 2 P. : 91 DEC 3 P. : 80 IN 3 P. : 127 ANGLES : 3°
TITLE:				REV.		
M60 RECEIVER						





NOTES:

- 1 FINISH $\sqrt{125}$ EXCEPT AS NOTED.
2. ALL EDGES SHALL BE BROKEN .005 ± .010 UNLESS OTHERWISE SPECIFIED.
3. HEAT TREATMENT- HEAT AT 1535° TO 1565° F. OIL QUENCH. TEMPER ONE HOUR TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
4. HEAT TREAT BEFORE MACHINING.
5. ALL RIVET HOLES AND THEIR C'SINKS MAY BE OMITTED OR LEFT UNDERSIZE PROVIDED THEY ARE PUT IN AT ASSEMBLY TO THE DIMENSIONAL REQUIREMENTS AT THE COMPONENT LEVEL. (L1)
6. MATERIAL- STEEL QQ-S-624 4140, 8640, 8740.

CONFIDENTIAL

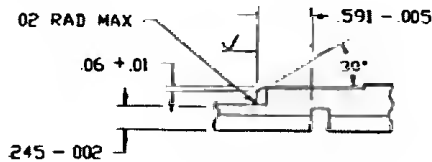
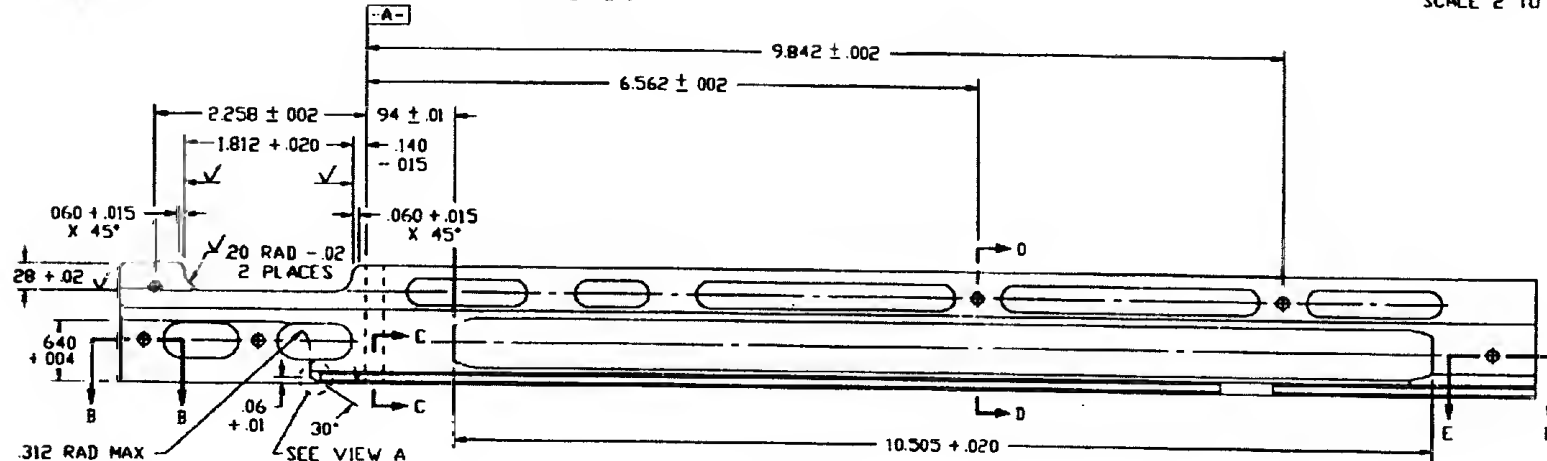
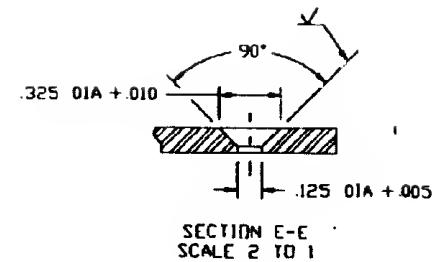
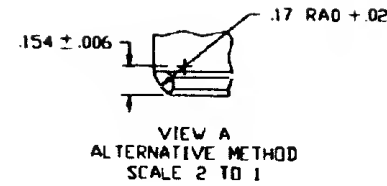
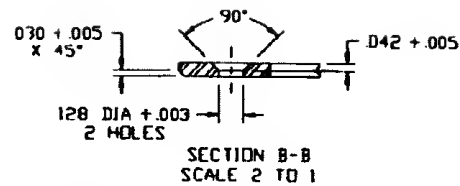
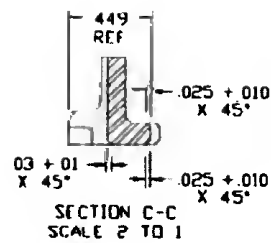
SECTION C-C
SCALE 2 TO 1

**RESTRICTED
MATERIAL**

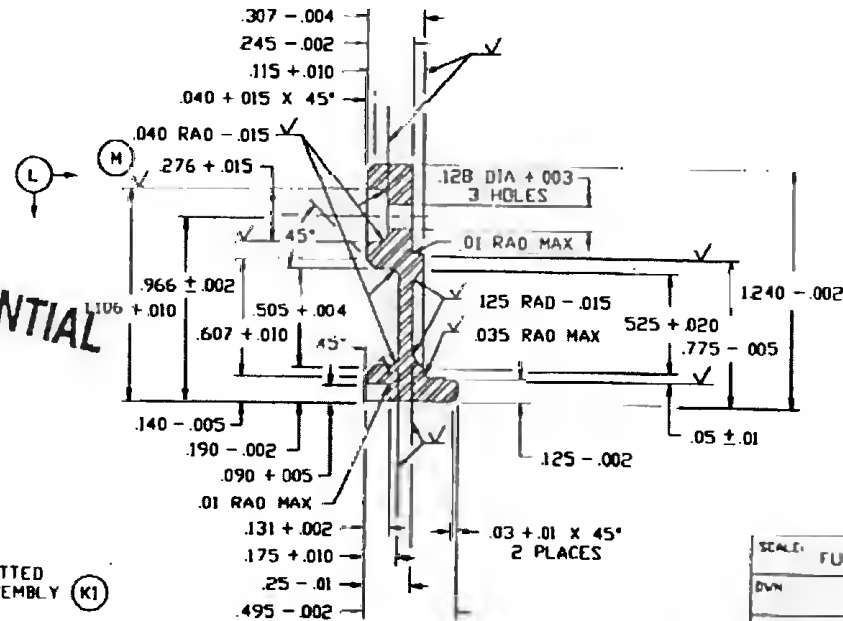
NEXT ASSEMBLY	F11686308	MG, 7.62 MM - M60, M60C.
	F11699805	M60D

CODE 10ENT NO. 19205
DRAWN FROM DRD PART NO. 7269259
SPRINGFIELD ARMOY ORDNANCE CORPS
DEPT OF THE ARMY
SPRINGFIELD 1, MASS

SYM	DESCRIPTION	SCALE	FULL	MATERIAL	SEE NOTE 6	CRD	TOLERANCES
K	REDRAWN WITH CHANGE SEE ED NO. SA30121	FINISH	SEE NOTE 1			DATE	DEC 2 PL : .005 H N : .127 ANGLES : 3°
L	(Q) SEE ED HRO 82232	TITLE	M60 RAIL, RECEIVER, LOWER	REV.			



VIEW F-F
(SEE SHEET 1)



CONFIDENTIAL

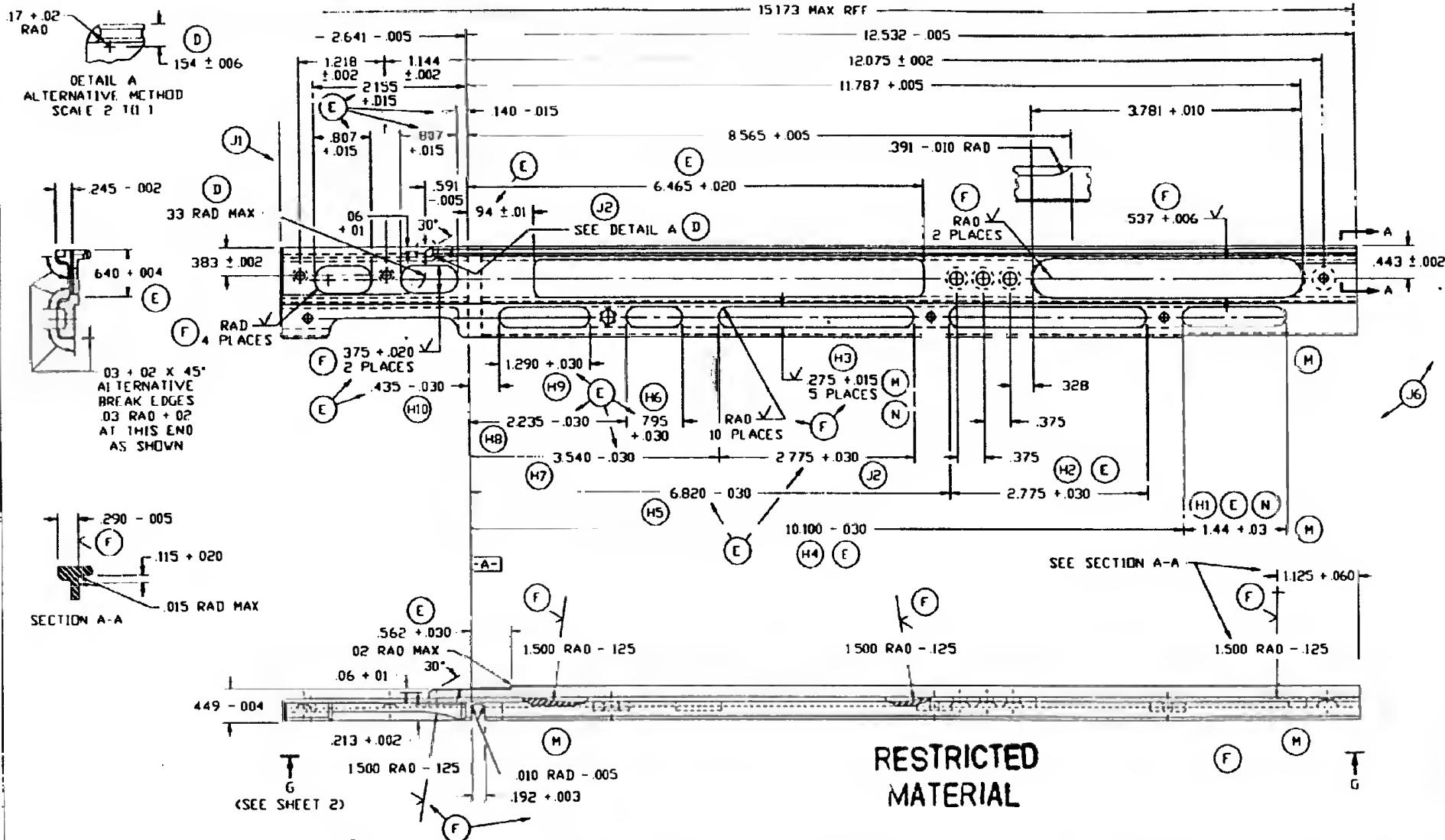
NOTE:
ALL RIVET HOLES AND THEIR COUNTERSINKS MAY BE OMITTED
OR LEFT UNDERSIZE PROVIDED THEY ARE PUT IN AT ASSEMBLY TO THE DIMENSIONAL REQUIREMENTS APPLICABLE
AT THE COMPONENT LEVEL. (K1)

RESTRICTED
MATERIAL

SYM	DESCRIPTION
J	REDRAWN WITH CHANGE SEE ED NO. 30122
K	(6) SEE ED HRD 82232
L	(1) SEE ERR HOR 10715
M	SEE ERR HOR 40604

CODE IDENT NO. 19204
DRAWN FROM ORD PART NO. 7269258
ROCK ISLAND ARSENAL
DEPT OF THE ARMY
ROCK ISLAND, ILL

SCALE	FULL	MATERIAL	SEE SHEET 1	QCD	DATE	REV	NO.
DWN		FINISH	SEE SHEET 1				
TITLE	MGO						
	RAIL RECEIVER, LEFT HAND						



NOTES:

1. FINISH 125/ EXCEPT SURFACES MARKED FINISH 250/
2. ALL EDGES SHALL BE BROKEN .005 + .010 UNLESS OTHERWISE SPECIFIED.
3. HEAT AT 1535° TO 1565° F OIL QUENCH TEMPER 1 HOUR TO HARDNESS SPECIFIED HEAT TREAT METHOD IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
4. HEAT TREAT BEFORE MACHINING.
5. FINAL PROTECTIVE FINISH: FINISH 53.12 OF MIL-STD-171
6. ALL RIVET HOLES AND THEIR C'SINKS MAY BE OMITTED OR LEFT UNDERSIZE PROVIDED THEY ARE PUT IN AT ASSEMBLY TO THE DIMENSIONAL REQUIREMENTS APPLICABLE AT THE COMPONENT LEVEL.
7. MIL-W-13855 APPLIES.
8. MATERIAL- STEEL QQ-S-624 4140 , 8640 , 8740

CONFIDENTIAL

SYM	DESCRIPTION
B	
C	REDRAWN & REVISED SEE ED SA24642
D	REF ED NO. SA24924
E	REF ED NO. SA26992
F	REF ED NO. SA27297
G	(1-2) SEE ED SA28042
H	SEE ED NO SA28992
J	(1-6) ED NO. SA
K	SEE ED NO. SA14466
L	(1-2) SEE ED HRD 82232
M	(1-6) SEE ERR HOR 10715
N	(3) SEE ERR HOR 60604

MEX1 ASSEMBLY	F11686308 F11699805	MG . 7.62 MM - M60 , M60C M60D
------------------	------------------------	-----------------------------------

CODE IDENT NO. 19204
DRAWN FROM ORD PART NO. 7269260
ROCK ISLAND ARSENAL
DEPT OF THE ARMY
ROCK ISLAND , ILL

SCALE	MATERIAL	CRD	TOLERANCES
FULL	SEE NOTE 8		DEC 2 PL : .02 H N : .01
DWN	FINISH SEE NOTE 1	DATE	DEC 3 PL : .005 H N : .027
TITLE	M60 RAIL , RECEIVER , RIGHT HAND	REV.	ANGLES : 3°
			NO